

Work Order ID 64483

Monday, December 06, 2010 3:36:05 PM



Page 1

Item ID: D2324

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 12/6/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 12/20/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: MF Date: 6-12-06 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2324

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D2324.

LP 10/12/07 (6)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/12/07

(46)

120

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 9:30 OVEN TEMPERATURE:

320° FINISH TIME:

10:00

6 10-12-8

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Monday, December 06, 2010 3:36:05 PM

Page 2

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Start Date: 12/6/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 12/20/2010 Req'd Qty: 6.00

Customer:







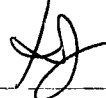
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00					10	12	08 
140  Packaging Packaging	Identify as per dwg & Stock Location: <u>511</u> Memo	0.00 0.00							10/12/08 SP 
150  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/12/09  MF 10-12-08

Picklist Print

Monday, December 06, 2010 3:36:05 PM

Page 1

Work Order ID: 64483

Parent Item: D2324

Parent Item Name: Strut



Start Date: 12/6/2010

Required Date: 12/20/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: E03.02.28 Reformat; Incorporated D2324-3 & D2324-5 KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN3-12A		Purchased	No			100	Each	70.0000	2	12			
Bolt													

Location	Loc Qty	Loc Code
----------	---------	----------

ST351	70	
114494	2	
114536	68	

AN960JD10	NAS1149D0363J	Purchased	No			100	Each	8.0000	4	24			
Washer													

Location	Loc Qty	Loc Code
----------	---------	----------

ST	6	
107715	6	
ST335	2	
105792	2	

D2324-3		Manufactured	No			100	Each	14.0000	1	6			
Bar													

Location	Loc Qty	Loc Code
----------	---------	----------

GA	4	
61714	4	
ST011	10	
62226	10	

Handwritten notes and signatures:

- Signature: *[Signature]* 12/10/07
- Signature: *[Signature]* 12/10/07
- Text: 17115622 (24x)
- Signature: *[Signature]* 12/10/07
- Text: 6

Picklist Print

Monday, December 06, 2010 3:36:05 PM

Page 2

Work Order ID: 64483



Parent Item: D2324

Parent Item Name: Strut

Start Date: 12/6/2010

Required Date: 12/20/2010

Start Qty: 6.00

Required Qty: 6.00

D2324-5

Manufactured No

100 Each

14.0000

2

12



Strap



EP 10/12/07

Location

Loc Qty

Loc Code

ST011

14

62672

14

12

MS21042L3

Purchased No

100 Each

1,247.000

2

12



Nut



EP 10/12/07

Location

Loc Qty

Loc Code

ST300

1247

114784

251

115835

996

12

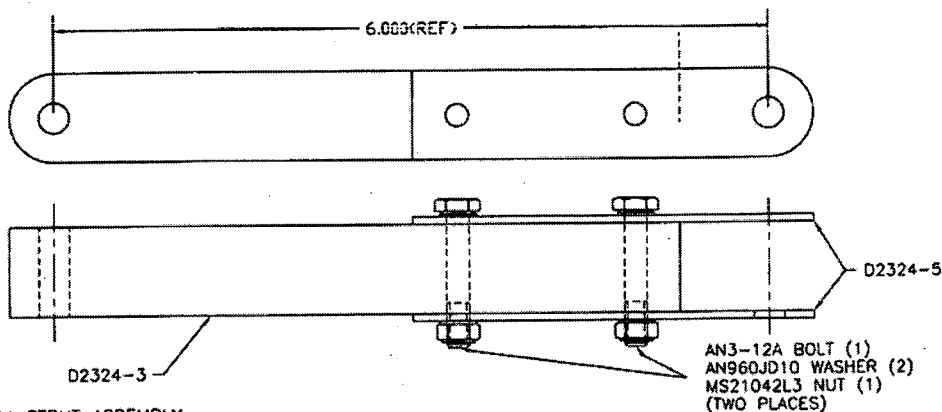
Monday, December 06, 2010 3:36:05 PM

Shop Packet Print

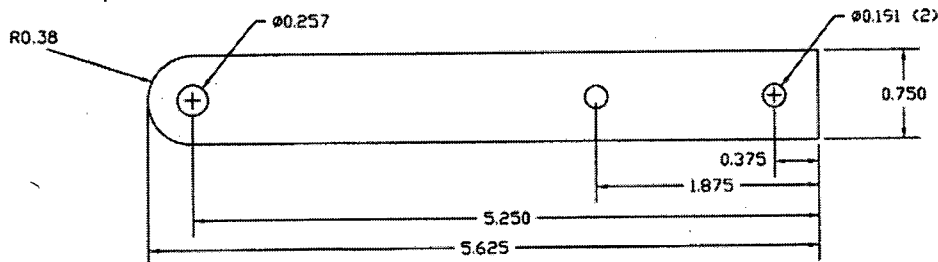
Page 2

DART

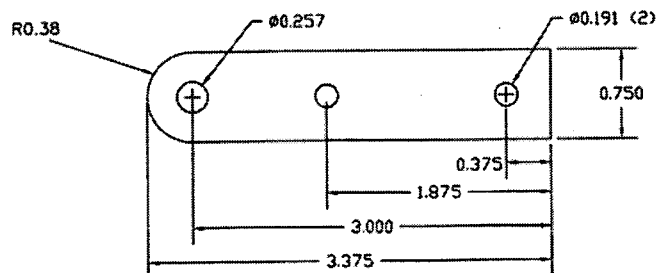
DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
<i>[Signature]</i>	<i>[Signature]</i>	D2324	SHEET 1 OF 1
DATE	TITLE		SCALE
04.12.14	STRUT		
A	94.11.08	NEW ISSUE	
B	96.05.07	UPDATE MATERIALS	
C	04.12.14	UPDATE NOTES	

RELEASED04.12.16 *[Signature]***D2324 STRUT ASSEMBLY**

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

**D2324-3**

- 1) MATERIAL: 6061-T6/T651 BAR (00-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X0.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

#64483